

Date: Monday, 15/12/2008 9:14:51 AM
 User: Linda Lacelle

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP WELDMENT
 Job Number : 44065 -1
 Estimate Number : 12577
 P.O. Number :
 This Issue : 15/12/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : LARGE FAB ASSY
 Previous Run : 43513
 Part Number : D3562042
 Drawing Number : D3562 REV E
 Project Number : N/A
 Drawing Revision : E
 Material :
 Due Date : 22/12/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment :
 Est Rev: A New Issue 06-11-09 JLM
 Est rev B ECN 987 07.10.09 EC verified by: DD
 Est Rev: C ECN1048 07-12-18 DD verified by: EC
 Est Rev: D 08-07-28 add chemical conversion coat DD
 verified by: EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Step Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Qty Part # Description Batch:
 1 D2622-120C Extrusion 042155

Check Material for any Dents or Defects

08.12.15

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

2-Deburr and bevel ends for welding

08.12.15

08.12.15

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.12.15 (83)

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08.12.15

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 44065

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



20



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-12-15 (X2)

6.0

D3560042

Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

ARM WELDMENT

Batch: *B42369 (7)*

SAD 09-02-03
SAD 09-01-07 (1)

7.0

D3560044

Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

ARM WELDMENT

Batch: *B42377 (7) B44474*

SAD 09-02-03
SAD 09-01-07 (1)

8.0

MS20600AD4W5

Blind Rivet



Comment: Qty.: 32.0000 Each(s)/Unit Total : 96.0000 Each(s)

Blind Rivet

batch: *M110927*

SAD 09-02-03 (1)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Drill Rivet holes as per dwg D3562. Touch up alodine

2- Rivet legs using Magnabond as per dwg D3562.

*****Ensure to wipe off any excess magnabond *****

A/R Magnabond 6398 Batch: *M108966*

SAD 09-02-03 (1)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S09/02/05 x12H

11.0

D2734

Step End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2734

End Cap

B43535

09-02-06 1

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 44065

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M108037

2-Grind end cap welds flush as per Dwg D3562

Handwritten: 09-02-06 1
09-02-09 1

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten: PD 09-02-10

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 09/02/11 (XIPM)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: HS

Handwritten: 09-02-12 (IRIA)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Handwritten: 5 14:45
OT. 320°
FT 15:15

Handwritten: M109996

Handwritten: 09-02-13

Handwritten: (IRIA)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: M110454

Handwritten: BR 09-02-17

Handwritten: (IRIA)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 09/02/18 ①

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 44065

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

6-A

09/02/18

①

20.0

QC21

FINAL INSPECTION/W/O RELEASE



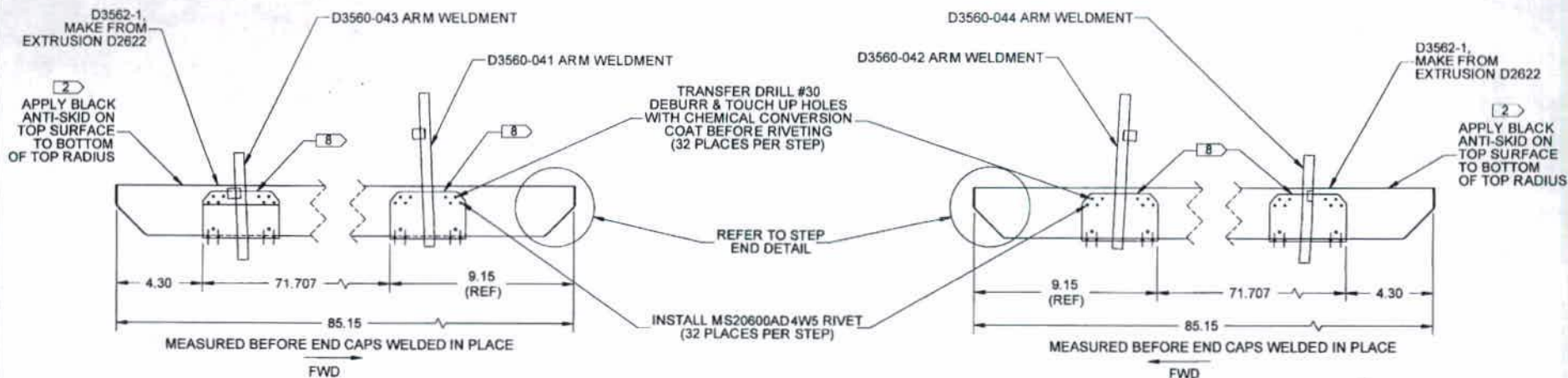
09/02/26

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF- 09-02-18



D3562-041 LH STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH:

i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY

ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

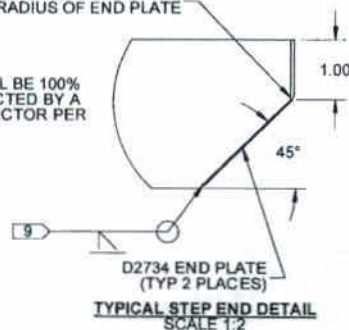
7) WEIGHT: 8.79 lbs

8) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.

9) WELDING: PER DART QSI 004

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



D3562-042 RH STEP ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3562-041	LH STEP ASSEMBLY
	X	D3562-042	RH STEP ASSEMBLY
1		D3560-041	ARM WELDMENT
	1	D3560-042	ARM WELDMENT
1		D3560-043	ARM WELDMENT
	1	D3560-044	ARM WELDMENT
32	32	MS20600AD4W5	RIVET
2	2	D2734	END PLATE

E	ADD QTY (2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.08.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN	gp		
DRAWN	fr		
CHECKED	le		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.01.11		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3562

REV. E
SHEET 1 OF 1

TITLE
STEP ASSEMBLY

SCALE
1:5

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